



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4017-041
Job Sheet 199721



Part No: D4017-041

Job Qty: 1 pcs

Part Name: Short Basket Base Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/29/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D4017 REV F SHEETS 1,2,3,4 IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC IPP REV:F 12.07.24 AS PER DWG REV.D DD VERF:EC IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/4/19	10/4/19	0.00	14.93	Large Fab - 1		CC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	10/4/19	10/4/19	0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1	10/4/19	10/4/19	0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		



Container No: S229380



Part: D4017 - 041

Job No: 199721

Serial No/Batch: S229380

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/05/19

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					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	10/4/19	0.00 0.17	Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	BA 19-11-8.
					Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	10/4/19	0.00 0.68	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BA 19-11-8.
					Powdercoat - 4 - B4B	
140	QC 3	1 pcs	10/4/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	BA 19-11-08
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	10/4/19	0.00 0.40	Handfinish - 4 - 1 - B4B	BA 19-11-08
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 -	

DAS
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9-889

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					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	10/4/19	0.00	0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 53	

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Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____), 1- assemble ribs , weld as per dwg D4017 using DT9610B 2- Cut
Descriptions: mesh as per dwg D4020-3 3- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary and trim to
 clear fasteners holes on the ends 4- weld hinge (3) and Mounting brackets as per dwg D4017 5- Weld D4672-3 blanking
 plates as per dwg
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 125 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)
 130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel), 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
 140 - (QC3- Inspect Part Finish)
 150 - (Assemble as per dwg)
 160 - (QC5- Inspect part completeness to step on W/O)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211240
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5211037
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5224354
D3916-5	Light Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	522770
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5213535
D4017-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5108068
D4017-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5179721
D4017-5	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5150234
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5220292
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214695
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5220279
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5211184
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5225815
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5226003
D4672-3	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5192444
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5218454
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5212101-2
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5216435
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5220499
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5202551
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5211537
NAS1149DN832J	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5034111
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216387

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	41	0
	D3913-15	1	17	0
	D3916-041	2	2	0
	D3916-5	1	19	0
	D4016-1	3	19	0
	D4017-1	1	6	0
	D4017-3	1	10	0
	D4017-5	1	5	0
	D4017-7	3	31	0
	D4017-9	2	8	0
	D4020-11	2	8	0
	D4021-1	3	19	0
	D4034-041	1	4	0
	D4034-043	1	5	0
	D4672-3	2	9	0
	M304EX0.75-16F	32	1,051	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	180	0
	D2931	2	677	0
	D4021-5	2	24	0
	MS20600-AD4W3	2	448	0
	MS21042L3	6	1,476	0
	NAS1149DN832J	2	1,080	0
	NAS1149F0332P	12	2,802	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By Lead hand / Supervisor _____ QC / QA Coordinator _____			